

Ship May 1

Dart Aerospace Ltd.

Date: Tuesday, 28/04/2009 10:02:01 AM
User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services
Job Number : 47557
Estimate Number : 13865
P.O. Number :
This Issue : 28/04/2009 **S.O. No.** :
Prsht Rev. : NC
First Issue : / / **Type** : SMALL / MED FAB
Previous Run : 47273
Written By :
Checked & Approved By :
Comment : Est Rev:A 09-04-20 new issue EC verified by:DD

Drawing Name : GUSSET ASS'Y
Part Number : D3929041
Drawing Number : D3929 REV A
Project Number : N/A
Drawing Revision : A
Material :
Due Date : 01/05/2009 **Qty:** 10 **Um:** Each

Additional Product

Job Number:



Seq. #: **Machine Or Operation:** **Description :**

1.0 M304S11GA 304/316 0.125 Sheet



Comment: Qty.: 0.4725 sf(s)/Unit Total : 4.7250 sf(s)
304/316 .0125" Sheet
Batch: 111018 IB 9-4-28

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET
1-Cut as per Dwg D3929
Dwg Rev: A
Prog Rev: A
2-Deburr if necessary

IB 9-4-28

IB 9-4-28



3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

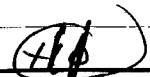
IB 9-4-28

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

S 07/07/28



5.0 D39071 Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total : 20.0000 Each(s)
Bushing
Batch: 647556

PD 09-04-29

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: GUSSET ASS'Y

Job Number: 47557

Part Number: D3929041

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Weld bushings D3907-1 as per dwg D3929

316L rod batch: H108160

DD 09-04-30 (11)

7.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PC 09-04-30

(11)

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 09/04/30 (11)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify as per dwg and Stock

Location: PPD 47636

S 09/04/30 (11)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

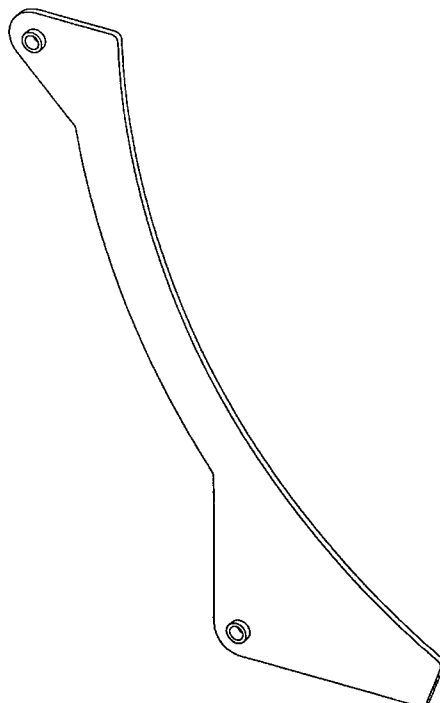
09/04/30

Job Completion

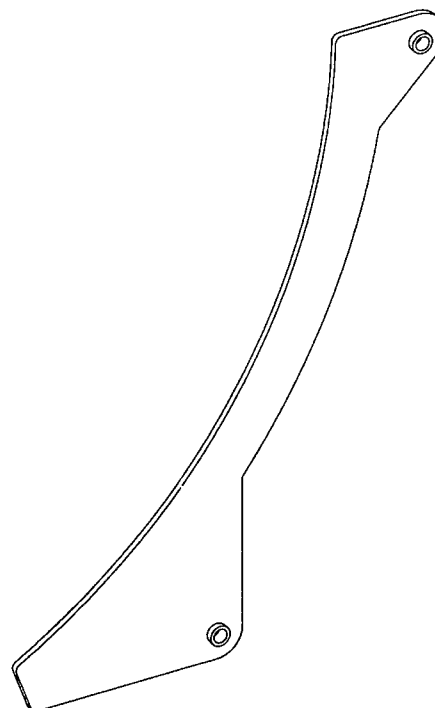


MF 09-04-30

ITEM	QTY -041	QTY -042	P/N	DESCRIPTION
1	X		D3929-041	GUSSET ASSEMBLY
2		X	D3929-042	GUSSET ASSEMBLY
11	2	2	D3907-1	BUSHING
12	1	1	D3929-1	SUPPORT GUSSET



D3929-041 GUSSET ASSEMBLY



D3929-042 GUSSET ASSEMBLY

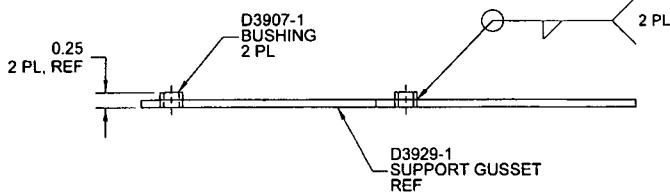
MP 10/15/17

RELEASED
8/6/12 MD

- NOTES:**
- 1) MATERIAL: N/A
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3929-04X" USING FINE POINT PERMANENT INK MARKER
 - 7) WEIGHT: 0.73 lbs EACH
 - 8) WELDING: PER DART QSI 004

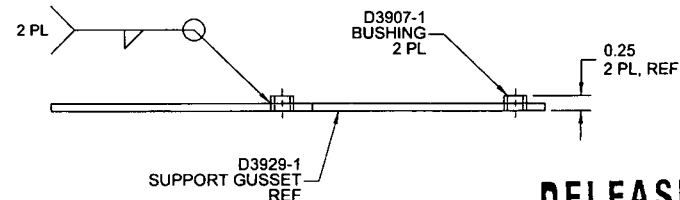
A	NEW ISSUE	DESCRIPTION	MB	09.04.03
REV.			BY	DATE
DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3929 TITLE GUSSET ASSEMBLY	REV. A	
DRAWN			SHEET 1 OF 3	
CHECKED			SCALE	
MFG. APPR.			NTS	
APPROVED		DATE 09.04.03		
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D3929-1
SUPPORT GUSSET
2 PL



D3929-041 GUSSET ASSEMBLY

D3929-1
SUPPORT GUSSET
2 PL

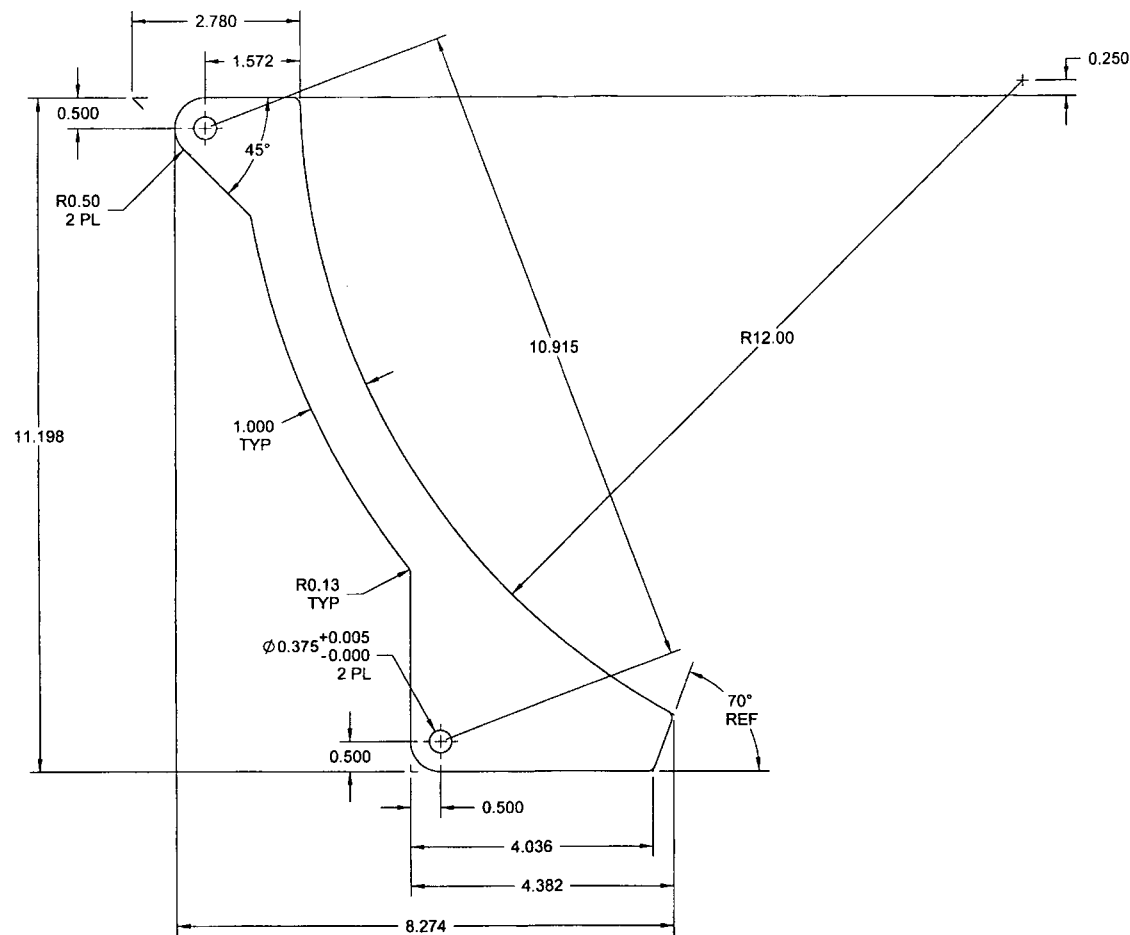


D3929-042 GUSSET ASSEMBLY

RELEASED
09/04/22

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3929	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		GUSSET ASSEMBLY	NTS
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47557



D3929-1 SUPPORT GUSSET

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET PER AMS 5513 OR 5524
11 GAUGE (0.125 THICK)
REF. DART SPEC. M304S11GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.72 lbs

RELEASED
8/04/22 JMD

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D3929	REV. A
MFG. APPR.			SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		GUSSET ASSEMBLY	NTS
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47557